

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014959**Date Inspected:** 17-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG TRIAL ASSEMBLY**SEGMENT 7DW**

This QA observed ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW) repair welding on weld joint identified as SSD25-PP057-047. ZPMC Quality Control personnel (QC) identified as Mr. Li Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR13660 procedure.

This QA observed ZPMC qualified welding personnel identified as 037996 perform Shielded Metal Arc Welding (SMAW) repair welding on weld joint identified as SSD25-PP057-099. ZPMC Quality Control personnel (QC) identified as Mr. Li Zai Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR13663 procedure.

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This QA observed ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW) repair welding on weld joint identified as SSD27-PP057-117. ZPMC Quality Control personnel (QC) identified as Mr. Li Zai Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-repair-1 UT repair for WR13655.

This QA observed ZPMC qualified welding personnel identified as 037996 perform Shielded Metal Arc Welding (SMAW) repair welding on weld joint identified as SSD27-PP057-099. ZPMC Quality Control personnel (QC) identified as Mr. Li Zai Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-repair-1 UT repair for WR13467

SEGMENT 8CE

This QA observed ZPMC qualified welding personnel identified as 067571 perform Shielded Metal Arc Welding (SMAW) on weld joint identified as SSD18-PP070-169. ZPMC QC identified as Mr. Li Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 049769 perform Shielded Metal Arc Welding (SMAW) repair welding on weld joint identified as SEG048B. ZPMC Quality Control personnel (QC) identified as Mr. Li Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR 1618 (R3) procedure.

SEGMENT 8CW

This QA observed ZPMC qualified welding personnel identified as 067667 perform Shielded Metal Arc Welding (SMAW) on weld joint identified as SSD12A-PP070-169. ZPMC QC identified as Mr. Li Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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